

628033

Dart Aerospace Ltd.

Date: Wednesday, 15/08/2007 3:50:04 PM
 User: Linda Lacelle

Process Sheet

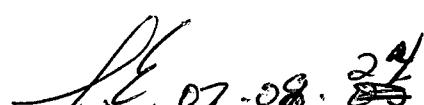
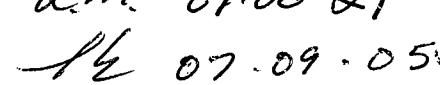
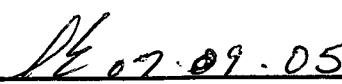
Customer: CU-DAR001 Dart Helicopters Services
 Job Number: 33923A
 Estimate Number: 11664
 P.C. Number: N/A
 This Issue: 15/08/2007 S.O. No.: N/A
 Prsht Rev.: NC
 First Issue: N/A Type: LARGE FAB ASSY
 Previous Run: 33921A
 Written By: 
 Checked & Approved By: 
 Comment: Est Rev B As Per Ecn 766 06-01-06 JLM

Drawing Name: FLOAT-STEP ASSEMBLY LH (206/407)
 Part Number: D2842041
 Drawing Number: D2842 REV B
 Project Number: N/A
 Drawing Revision: B
 Material: N/A
 Due Date: 10/09/2007 Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D2622120C	Extrusion	
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)		
	Qty Part # Description Batch:	332858	
	Check Material for any Dents or Defects		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1		
	1-Cut D2842-1 using D2622 extrusion as per Dwg D2842		am 07.08.24
	2-Drill D2842-1 using Jig DT8271 as per Dwg D2842		
	3-Deburr and bevel ends for welding		14.07.09.05
3.0	D2734	206 Step Endplate	
	Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)		
	206 Step Endplate		
	Pick:		
	Qty Part Number Description Batch	330883	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:04 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33923A

Part Number: D2842041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-3Lug 333226

16.07.09.05 3

5.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-1 Lug 333807

16.07.09.05 3

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT as per Dwg D2842

16.07.09.05 3

A/R AL Rod Batch: 1103794

1104721

2-Grind end cap weld flush a.m

07.09.06

3

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07.09.06

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33923A

Part Number: D2842041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SL 01-09-10 3

11.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M103794

SL 02-09-10 3

2-Grind end cap weld flush.

a.m 02.09.10 3

12.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SL 02/09/11 3

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 02/09/11 3

14.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4/08

SL 07-09-11 3

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

3

16.0 NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

3 NAS1329C3KB130Insert

M105385

SL 01.09.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 33923A

Part Number: D2842041

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS27039C1-07 Screw M105426

M1 07 09 11



18.0 NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 NAS1515H3L WASHER M104603

M1 07 09 11



19.0 AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN960C10L WASHER M105143

M1 07 09 11



20.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

M1 07 09 11 (3)

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 105386

M1 07 09 11

(3)

21.0 QC5

INSPECT WORK TO CURRENT STEP



JUL09/12 (3)



Comment: INSPECT WORK TO CURRENT STEP

22.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PP 33523

10/13/17 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33923A

Part Number: D2842041

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0 QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07/09/18

W 07/09/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

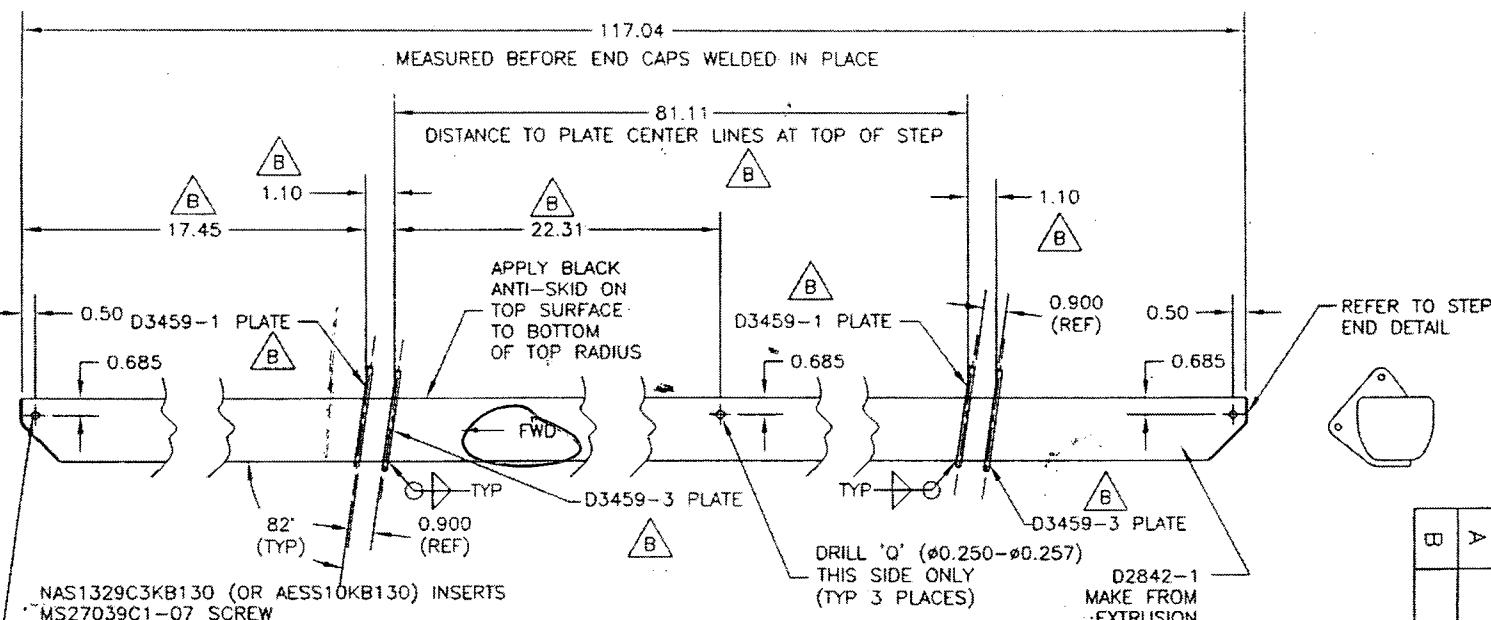
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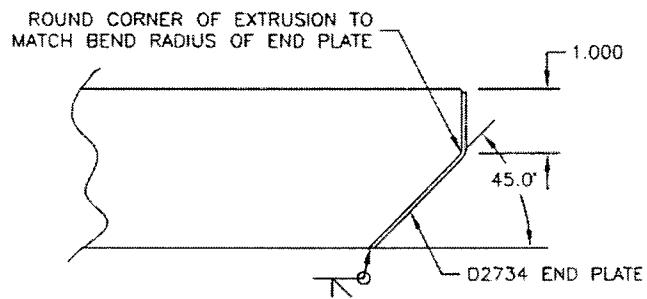
WB 399238

DART



D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
1	041	D2842-041	LH STEP ASSEMBLY
X		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-14-14

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC.	
DATE	APPROVED	DRAWING NO.	REV. B
05.09.23		D2842	
A		98.10.13	NEW ISSUE
B		05.09.23	RE-DESIGN, ADD D3459-1/-3

SHEET 1 OF 1
TITLE: 206L/407 FLOAT STEP ASSEMBLY
SCALE: NTS